

Date: Monday, 18/09/2006 11:37:25 AM
 User: Linda Macelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 28631
 Estimate Number : 12530
 P.O. Number :
 This Issue : 18/09/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : 18/09/2006 Type : SMALL /MED FAB
 Previous Run :
 Written By : W
 Checked & Approved By : W
 Comment : Est Rev:A New Issue 06-09-18 JLM

Part Number : D35471
 Drawing Number : D3557 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : U/R
 Material :
 Due Date : 25/09/2006 Qty: 5 Um: Each

Additional Product

Job Number:



6061.125

Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S125 <u>ML 08 09 19</u>	2024-T3 .125 sheet <u>batch: M101092 M 01003</u>
2.0	WATER JET	FLOW WATER JET



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 FLOW WATER JET
 1-Cut as per Dwg D3547
 Dwg Rev: Pre1
 Prog Rev: Pre1
 ****Ensure Grain Direction is Correct*****

ML 08 10 03ML 08 09 19

(5)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 INSPECT PARTS AS THEY COME OFF MACHINE

ML 08 10 04ML 08 19

(5)

4.0 QC8 SECOND CHECK



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 SECOND CHECK

JM 06.10.03 (5)

5.0 BRAKE NC NC BRAKE



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
 NC BRAKE
 Bend as per Dwg D3557

SPB 04/10/03

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/06/03	5	2 piece crack Broke		Scrap & destroy	SB 06/10/03			

NOTE: Date & initial all entries

Date: Monday, 18/09/2006 11:37:25 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 28631

Part Number: D35471

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
INSPECT WORK TO CURRENT STEP

FL 06-10-04 (3)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

a.m 06-10-04 (3)

8.0

POWDER COATING

POWDER COATING



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-10-04 (3)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06 10 04 (3)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PACKAGING RESOURCE #1
Identify and Stock
Location: _____

1806-10-05 (3)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
FINAL INSPECTION/W/O RELEASE

Job Completion



W 2010-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

162

☒ First Article ☒ Prototype

Measured by: <i>MM</i>		Audited by:		Prototype Approval:	
Date: <i>08.10.04</i>		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

m 102087

D INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

ify that the material covered by this certificate has been inspected with, and has been found to meet, the
 irements described therein, including any specifications forming a part of the description and that samples
 of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

whe

Mark J. Vrablec
 Manufacturing Davenport Works

Kenton P. Young
 Quality Assurance Manager

624188
Ship Date

0
B.L. No.

Invoice No.Alcoa No. Item

Page 1

2006-06-22

1567488

00000

1841748-1

P.O. No./Govt Contract No.Customer Mfg Order

CI9208

C&B

DS-94537-1

COPPER BRASS SALES
 415 STATE PARKWAY
 SCHAUMBURG, IL 60195

Item Description

1250 IN TK X 48.000 IN W X 144.000 IN LN CAT D 126185 (N) (A/T 2024-
 T3 PLAT SHEET MILL FINISH {{ P/N 061913-0 }}. PER AMS-QQ-A-
 250/4 REV A & (EXCEPT OIL &
 MARKING) AMS4037 REV N & (EXCEPT MARKING)
 ASTMB209 REV 04 ((MARKED)) INTERLEAVED SKID
 WGT: 4500 LB QUAN TOL +/-10 %
 CQR D126185 REV 27 QRR 003140 CUST REQ 06-05-
 07 *** W/E 06-05-13 ***

Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
7021	327373	1877	22	PC	

r CQR: D126185.27

PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E, AMENDMENT 2.
 PRODUCED AND MARKED TO THE REQUIRE- MENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/4.

26185.27 -Specification Limits -----

r ng Transv.	Max Min	UTS	TYS	EL4D
		KSI	KSI	PCT
		63.0	42.0	15

Composition	Max Min	SI	FE	CU	MN	MG	CR	ZN	TI	Each	Total	Other	Other
												Aluminum	
24		.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15	REMAIN	

327373 -Mechanical, Physical, Metallography, Quantometer Results -----

r ng Transv.	Test	No.	Max Min	UTS	TYS	EL4D
				KSI	KSI	PCT
5				67.3	47.4	19.1
				66.7	47.2	18.2

m101092

P/N: 063083

DOC : V/0080170801

DATE : 2005-10-14

PROD. REF. : 0000185084/001

NRBST : 68721/01

PAGE : 1/ 2

INSPECTION CERTIFICAT



Corus Aluminium N.V.
A Stedeliaan 87, 2570 Duffel - Belgium
Tel 32 (0)15 30 21 11 - Fax (0)15 30 27 94

CUSTOMER : CORUS ALUMINIUM ROLLED PRODUCTS US

475 N. MARTINGALE ROAD, SUITE 400
SCHAUMBURG 60173 USA

YOUR ORDER NUMBER : PO 5141 (COPPER'S PO# CF4015)
OUR ORDER NUMBER : 68721/01
DOCUMENT NUMBER : V/0080170801

DESCRIPTION : ALU SHEETS (SPENC.) M 6061-T6 AMS-QQA-250/11 AMS 4027M ASTM B209-04
DIMENSIONS : 144" X 48" X .125"
ARTICLE NO. :

COIL NUMBER	CAST NUMBER	CHEMICAL COMPOSITION (%)							
		SI	FE	CU	MN	MG	CR	TI	ZN
		MIN							
		MAX							
001	1468431	0,40	0,7	0,15	0,15	0,8	0,04	0,15	0,25
		0,8		0,40		1,2	0,35		
		0,71	0,4	0,23	0,07	1,0	0,14	0,03	0,01
OTHERS : EACH		:			MIN		0,05 MAX		
TOTAL		:			MIN		0,15 MAX		

TEST- NUMBER		MECHANICAL PROPERTIES			1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI	
		/A = REAR END	/M = MIDDLE	/V = FRONT END	/O = RANDOM SAMPLING	
		RM	RP02	A		
		KSI	KSI	%		
	MIN	42	35	10		
	MAX					
001	/A	47	40	16		
001	/M	47	40	16		
001	/V	47	40	16		

Date May 22, 2006
Cust. Duffel Aerospa
W/O # 104437
Qty 85 Pcs.
☒ K10120 ☐ Special Instructions
☐ Port # ☒ Alloy ☒ Heat/Lot
These documents are for material shipper
P00000127
Brass Sales
Duffel Aerospa
Customer ATTN: QA

Corus Aluminium Rolled Products - Corus Aluminium Extrusions